

Work Order ID 126706

126706

Page 1

Monday, November 24, 2014 8:02:03 AM

Item ID: D206-642-351

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube, Low & High Gear with Run-on Landing Wearplates Fits LH or RH

Start Date: 11/24/2014 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/24/2014 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-11-24 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4361-041	A								
IIN-D206-642	Q								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc. Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-642-351	CHG001							

MLS 15-03-17

sil

MAR 16 2015

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B126706

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Item ID: D206-642-351

Accept

N900040100Setup Start ***NS1***

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Start Date: 11/24/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/24/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
	2-Remove ridge on inside of Fwd edge of tube as per Dwg D4361								
	3-Weld Fwd Cap as per Dwg D4361 Use aluminum rod. Grind D2647 to fit as required. A/RAluminum Rod <u>M13017/M130812</u>								
	4-Grind weld flush to cap on top surface only.								
	5-Cut aft end to length as per dwg D4361								
	6-Drill pilot holes using drill Jig DT8168A and DT8168B and DT8025. Most Fwd wearplate hole to be laid out manually.								
	8-Open Aft Cap Hole using # Drill Bit								
	9-Open holes for Tow Ring to Ø0.625" as per Dwg D4361, D4361-041 Drilling Detail								
	10-Remove inner indexing ridge on aft end of skidtube as per Dwg D4361								
	11-Deburr and Blow out all chips from inside the tube								

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 Item Name: Replacement Skidtube, Low & High Gear with Run-on Landing Wearplates Fits LH or RH
 Start Date: 11/24/2014 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 11/24/2014 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Skidtubes	0.00							
130									
Skidtubes	Memo	0.00							
Skidtubes	1-Open holes to finished size as per Dwg D4361, D4361-041 Drilling Detail								
	2-Countersink crossbolt spacer holes as per Dwg D4361								
	3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.								
	4-Bond D2654-5 web in place as per QSI 015, Ensure holes line up. Allow 12 Hrs. cure time								
	Start Date: <u>14-12-22</u> Time: _____								
	Finish Date: _____ Time: _____								
	A/R Sikaflex-291: <u>128979</u>								
	Sikaflex expiry date: <u>15-1-1</u>								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									

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Item ID: D206-642-351 Accept ***N900040100*** Setup Start ***NS1***
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Start Date: 11/24/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/24/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Skidtubes	0.00							
150									
Skidtubes	Memo	0.00							
Skidtubes	1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D4361. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod A/RAluminum Rod <u>ML30137</u>								
	2-Grind welds flush as per Dwg D4361.								
	3-Counterbore 5/16" x 0.750" deep as per Dwg D4361. Deburr								
	4- Install nut plate as per dwg								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00							
Quality Control									

BE15-01-14

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Item ID: D206-642-351

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

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Start Date: 11/24/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/24/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

180

QC

Memo

Quality Control

190	Pressure Wash per QSI005 4.3	0.00							
-----	------------------------------	------	--	--	--	--	--	--	--

190

HandFinish

Memo

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

200

Powdercoat

Memo

Powder Coating

Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

START TIME: 9:00OVEN TEMPERATURE: 320°FINISH TIME: 9:30DAS
9
9-8915-2-4
JL/DL1 15-2-17
DAS 34 9-89

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Item Name: Replacement Skidtube, Low & High Gear with Run-on Landing Wearplates Fits LH or RH

Start Date: 11/24/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/24/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC3- Inspect Part Finish	0.00							38 9-89
230									
QC	Memo	0.00							
Quality Control									FEB 19 2015
240	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
240									
QC	Memo	0.00							
Quality Control									FEB 19 2015
250	Packaging	0.00							
250									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-351								
	Location: <u>085</u>								
	PPP Rev: _____								

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Item ID: D206-642-351

Accept

N900040100Setup Start ***NS1***

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Start Date: 11/24/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/24/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC21- Final Inspection - Work Order Release	0.00							
260									
QC	Memo	0.00							
Quality Control									

MLS 1503-18

11.3.17

Picklist Print

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Work Order ID: 126706

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Parent Item: D206-642-351

D206-642-351

Parent Item Name: Replacement Skidtube, Low & High Gear with Run-on Landing Wearplates Fits LH or RH

Start Date: 11/24/2014

Required Date: 11/24/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-07-09 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620

Manufactured

No

Each

3.0000

1

D2620

Skidtube, 206 Skidtube

**

BE 14-1215
B126930 x1

Location

Loc Qty

Loc Code

LG002

3

122224

3

D2654-5

Manufactured

No

Each

4.0000

1

D2654-5

Web

**

BE 14-12-22
B126931 x1

Location

Loc Qty

Loc Code

LG002

4

115438

1

122929

3

D2646

Manufactured

No

Each

32.0000

1

D2646

Aft Cap

**

15/02/17

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

B128761

X1

FP001

11

103306

2

107857

1

113830

1

114495

6

126636

1

FP002

17

119656

17

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Parent Item: D206-642-351

D206-642-351

Parent Item Name: Replacement Skidtube, Low & High Gear with Run-on Landing Wearplates Fits LH or RH

Start Date: 11/24/2014

Required Date: 11/24/2014

D2647

Manufactured No

Each

20.0000

Start Qty: 1.00

Required Qty: 1.00

1

D2647

Cap

**

BB 11-12-15

Location

Loc Qty

Loc Code

LG001

20

114961

20

1

D2649

Manufactured No

Each

278.0000

23

D2649

Cross Bolt Spacer

**

BB 15-01-14

Location

Loc Qty

Loc Code

LG001

278

107906

3

112728

6

113811

2

120508

195

23 +1

123099

66

90497

6

D2651-1

Manufactured No

Each

236.0000

4

D2651-1

Plug

**

yl 15/02/17

Location

Loc Qty

Loc Code

FP001

236

104843

1

111875

16

112725

164

x4

114496

55

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Parent Item: D206-642-351

D206-642-351

Parent Item Name: Replacement Skidtube, Low & High Gear with Run-on Landing Wearplates Fits LH or RH

Start Date: 11/24/2014

Required Date: 11/24/2014

D2651-3

Manufactured No

Each

1,068.000

4

Start Qty: 1.00

Required Qty: 1.00

D2651-3

O-Ring

**

all 11/02/17

Location

Loc Qty

Loc Code

FP001

1068

104725

8

112214

17

113577

55

120110

988

✓

D2680-041

Manufactured No

Each

27.0000

1

D2680-041

Nut Plate

**

BB15-01-14

Location

Loc Qty

Loc Code

LG001

27

110751

2

115056

25

/

D3873-1

Manufactured No

Each

116.0000

18

D3873-1

Bushing

**

all 11/02/17

Location

Loc Qty

Loc Code

ST063

116

104858

5

105611

8

109110

1

121363

3

122917

39

124192

60

x18

D4364-041

Manufactured No

Each

0.0000

1

D4364-041

Run-on Landing Wearplate Fwd

**

B127306 (1x) all 11/02/17

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Shop Packet Print

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D206-642-351

Parent Item Name: Replacement Skidtube, Low & High Gear with Run-on Landing Wearplates Fits LH or RH

Start Date: 11/24/2014

Required Date: 11/24/2014

D4364-043 Manufactured No

Each 2.0000 1

Start Qty: 1.00

Required Qty: 1.00

D4364-043

Run-on Landing Wearplate Aft

**

11/24/14

Location

Loc Qty

Loc Code

FP002

2

1312531

✓1

110647

1

114538

1

AN3-36A Purchased No

Each 110.0000

9

AN3-36A

Bolt

**

11/24/14

Location

Loc Qty

Loc Code

ST347

110

15072

72

✓9

15924

38

NAS1149C0332R Purchased No

Each 6,579.000

9

NAS1149C0332R

WASHER

**

11/24/14

Location

Loc Qty

Loc Code

CA

83

m129682

83

11131340

✓9

ST278

6496

122063

41

125654

237

m126319

51

m127306

1425

m127831

26

m128591

75

m129499

191

m130325

3450

m130466

1000

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Work Order ID: 126706

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Parent Item: D206-642-351

D206-642-351

Parent Item Name: Replacement Skidtube, Low & High Gear with Run-on Landing Wearplates Fits LH or RH

Start Date: 11/24/2014

Required Date: 11/24/2014

MS21042-3	MS21042L3	Purchased	No	Each	1,100.000	Start Qty: 1.00	Required Qty: 1.00
						9	
MS21042-3						**	<i>all 15/02/17</i>
Nut / use MS21042L3							

Location	Loc Qty	Loc Code
CA	289	
M129682	289	
ST305	811	
123352	11	
M128770	700	<i>X9</i>
M129541	100	

NAS1149D0332J	Purchased	No	Each	2,242.000
NAS1149D0332.J				
Washer				

**

2

all 15/02/17

Location	Loc Qty	Loc Code
CA	33	
m129682	33	
ST260a	1925	
m130325	1925	<i>X2</i>
ST269	284	
m128606	14	
m128612	245	
m129624	25	

CCR264SS3-3	Purchased	No	Each	397.0000
CCR264SS3-3				
Cherry Rivet				

**

2

BE 15-01-14
m128606 x 2

Location	Loc Qty	Loc Code
ST321	397	
113973	26	
m126282	43	
m126333	52	
m128636	76	
m128818	200	

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Parent Item: D206-642-351

D206-642-351

Parent Item Name: Replacement Skidtube, Low & High Gear with Run-on Landing Wearplates Fits LH or RH

Start Date: 11/24/2014

Required Date: 11/24/2014

CR3212-4-3

Purchased

No

Each

Start Qty: 1.00
300.0000

Required Qty: 1.00
2

CR3212-4-3
Cherry Rivet

**

BE 15-01-14
m123265x2

Location

Loc Qty

Loc Code

CCK004

200

m126320

200

ST320

100

124259

100

MS27039-1-08

Purchased

No

Each

1,608.000

2

MS27039-1-08
Screw

**

lll 15/02/17

Location

Loc Qty

Loc Code

ST285

1608

m125654

3

m126319

8

m128636

1597

MS27039-4-06

Purchased

No

Each

44.0000

1

MS27039-4-06
Screw

**

lll 15/02/17

Location

Loc Qty

Loc Code

ST283

44

m126534

44

x1

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Parent Item: D206-642-351

D206-642-351

Parent Item Name: Replacement Skidtube, Low & High Gear with Run-on Landing Wearplates Fits
LH or RH

Start Date: 11/24/2014

Required Date: 11/24/2014

NAS1149D0463J

Purchased

No

Each

7,101.000

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463.J

WASHER

**

12/02/14

Location

Loc Qty

Loc Code

CA

459

M129682

459

ST260a

6523

M129390

1593

M130799

4930

ST269

119

I6941

8

M126221

20

M127813

6

M127904

16

M128591

44

M128995

25

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D4361-041	SKIDTUBE ASSY
	X	D4361-043	SKIDTUBE ASSY
1	1	D2600-1-160	EXTRUSION
1		D2654-5	WEB
	1	D2654-7	WEB
1	1	D2646	AFT CAP
1	1	D2647	CAP
23	26	D2649	CROSS BOLT SPACER
4	8	D2651-1	PLUG
4	8	D2651-3	O-RING
1	1	D2680-041	NUT PLATE
18	20	D3873-1	BUSHING
1		D4364-041	FWD WEARPLATE ASSY
1		D4364-043	AFT WEARPLATE ASSY
	1	D4366-041	FWD WEARPLATE ASSY
	1	D4366-043	AFT WEARPLATE ASSY
9	10	AN3-36A	BOLT
9	10	NAS1149C0332R	WASHER (OR AN960C10L)
9	10	MS21042-3	NUT
2	2	NAS1149D0332J	WASHER (OR AN960JD10L)
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	MS27039-1-08	SCREW
1	1	MS27039-4-06	SCREW
1	1	NAS1149D0463J	WASHER (OR AN960JD416)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2654-5/-7 WEB
-POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4361-041 = 37.5 LBS
D4361-043 = 44.3 LBS
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE.
A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

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 WITHOUT NOTICE
 WORK ORDER

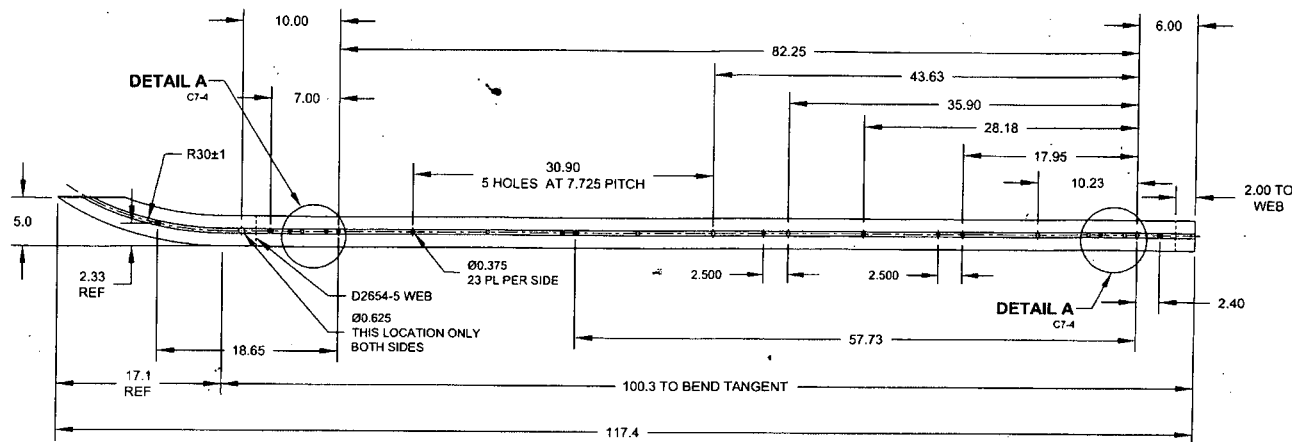
126706 MJS
 14-11-24

RELEASED
 2011-09-12

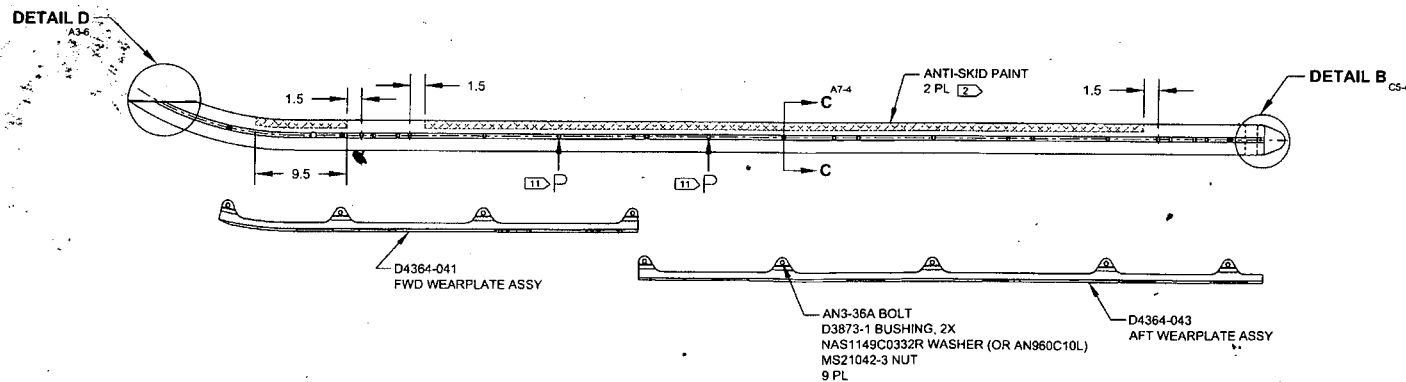
REV.	DESCRIPTION	SC	DATE
DESIGN	SC		
DRAWN	SC		
CHECKED	Q		
MFG. APPR.	E		
APPROVED	AP		
DE APPR.	A		
DATE	11.05.05		

DART AEROSPACE USA, INC
 PORT HADLOCK, WA
 DRAWING NO. D4361
 TITLE 206L/407 SKIDTUBE ASSEMBLIES
 REV. A
 SHEET 1 OF 4
 SCALE NTS

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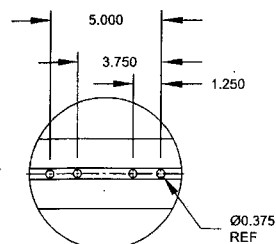
D4361-041 BENDING/DRILLING DETAIL



D4361-041 ASSEMBLY/FINISHING DETAIL

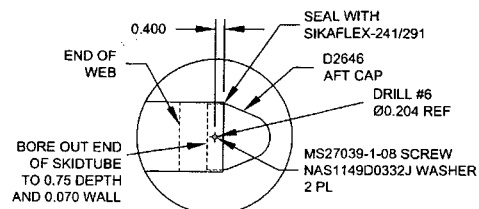
RELEASED
2011-09-12
JH

DESIGN	SC	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	47	DRAWING NO.	REV. A
MFG. APPR.	47	D4361	SHEET 2 OF 4
APPROVED	47	TITLE	SCALE
DE APPR.	47	206L/407 SKIDTUBE ASSEMBLIES	NTS
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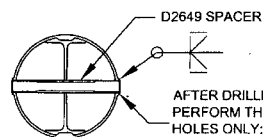
DETAIL A

C3-2
D7-2
C3-3
D6-3



DETAIL B

B2-2
B1-3

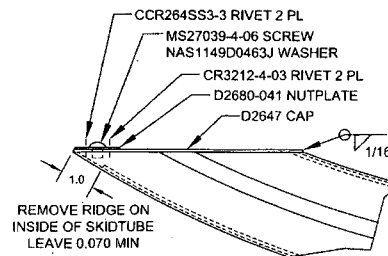


AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. CBORE TO Ø0.313 X 0.75 DP

SECTION C-C
FOR Ø0.375 HOLES ONLY

B4-2
B5-3

ORIENTATION OF
D2680-041



DETAIL D

B7-2
B7-3

DETAIL D NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
2011-09-12

DESIGN	SC	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>47</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>47</i>	D4361	SHEET 4 OF 4
APPROVED	<i>47</i>	TITLE	SCALE
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